

Date: Thursday, 2/21/2008 9:26:06 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 37566	
Estimate Number : 10533	
P.O. Number :	Part Number : D2573
This Issue : 2/21/2008 S.O. No. :	Drawing Number : D2573 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 37552	Material :
Written By :	Due Date : 3/15/2008 Qty: 6 Um: Each
Checked & Approved By : <u>08 02 21</u>	
Comment : Est: 1 As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2573
Ensure that grain is along 7.75" length
Batch No: B34875

08/02/27

6

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 37566 Double check by: DJP

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

08/03/04 6

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

08/03/04 6

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/03/04 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 28/03/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/21/2008 9:26:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 37566

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Handwritten signature
08-03-05

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Handwritten initials

08-03-06 (X6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten signature 08/03/06 (6X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-03-06 (6X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 433

Handwritten signature 08/03/06 (X6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/07

Job Completion



Handwritten signature 2008/3/07 (6)

DART AEROSPACE LTD	Work Order:	37566
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

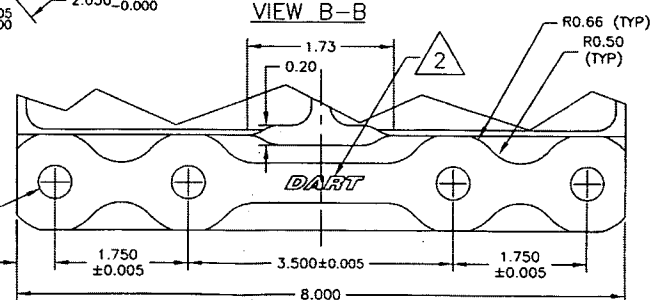
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.004	8.004				
F	0.490	0.510		.502	.503				
G	0.257	0.262	DT8683	.258	.258				
H	0.375	0.380	DT8684	.376	.376				
I	0.490	0.510		.503	.502				
J	1.174	1.184		1.175	1.175				
K	0.558	0.578		.571	.570				
L	1.174	1.184		1.179	1.175				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.126	.126				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.254	.254				
S	0.115	0.135		.126	.125				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.228	3.228				
V	0.230	0.250		.243	.243				
W	0.115	0.135		.127	.127				
X	0.308	0.313		.310	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.369	.370				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.628	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.254	.254				
AE	1.500	1.520		1.515	1.515				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.253	.253				
AI	2.000	2.020		2.004	2.003				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	SA
Date:	08/03/04

Audited by:	
Date:	




Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06



DETAIL C
SCALE 4:3

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
CHECKED 		APPROVED 
DATE 05.07.13		 DART AEROSPACE LTD. <small>HAMPSHIRE, ONTARIO, CANADA</small> DRAWING NO. D2573 TITLE OUTER AFT SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WOLK ORDER
NO. 32566